

SMALL FAB



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400221

Job Sheet 178351



007226

Part No: RBT400221

Job Qty: 1 ea

Part Name: Drive Shaft Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 7/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400221 REV 3A IPP REV A 18.05.29 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	1 pcs	7/18/18	7/18/18	0.00	0.13	Small Fab-9		
110	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC5		
120	QC	1 pcs	7/18/18	7/18/18	0.00	0.00			
130	Packaging	1 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea	7/18/18	7/18/18	0.00	0.00	QC21		

Part Op 100 - 1-Assemble as per DWG 2-Retrieve 1/16" 316L welding rod for RBT400221-119 from welders and cut to length

Descriptions: Install tag

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400221-109	Turnbuckle	2 Ea (2 ea)	90-Start up Operation	5096433
RBT400221-120A	L/H Wire Assy	2 Ea (2 ea)	100-Small Fab	5138000
RBT400221-120B	R/H Wire Assy	2 Ea (2 ea)	100-Small Fab	5138004
1632T22	Aluminum Tag 1" X 2" X 0.04"	2 pcs (2 ea)	100-Small Fab	5118668

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT400221-109	2	0	0
100-Small Fab	1632T22	2	71	0
	RBT400221-120A	2	0	0
	RBT400221-120B	2	0	0

Part Specifications

Specifications could not be found.



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Plex 7/18/18 1:20 PM dart.logan.david

Container No: S140458



Part: RBT400221

Job No: 178351

Serial No./Batch: S140458

Revision: 3A

Inspector:

Exp Date:

Instructions:

Date: 12/27/18

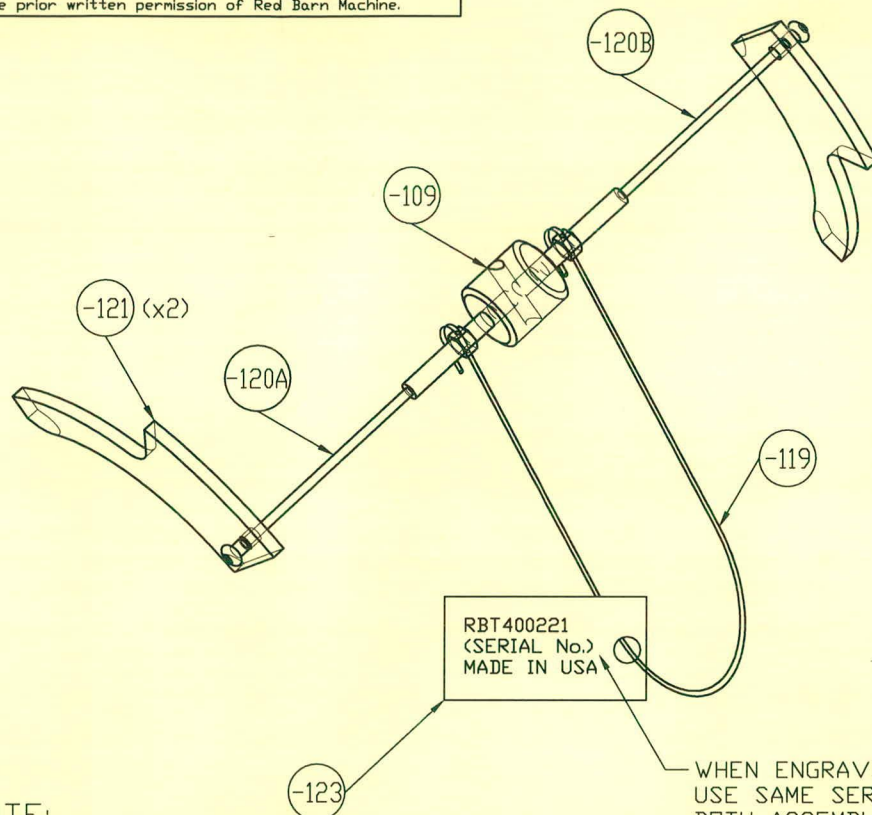
240

32

28-2

07

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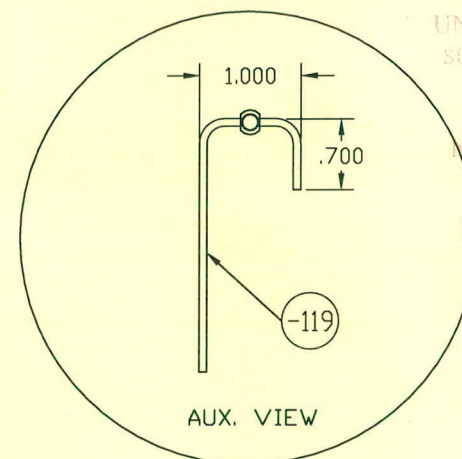
NOTE:

TWO ABOVE ASSEMBLIES REQUIRED PER TOOL.

ASSY QTY	QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
			-109	2	TURNBUCKLE	STRESS PROOF	Ø3/4 x 1-5/8	3
			-119	2	WIRE	S.S.	Ø1/16 x 14 (WELDING ROD), BEND IN LOOP GOING THROUGH TURNBUCKLE END FITTINGS	1
			-120A	2	L/H WIRE ASSY.			2
			-120B	2	R/H WIRE ASSY.			2
1	1		-121		GRIPPER	4140 Q&T	Ø7 x 1/4 (MAKES 4)	3
1	1	B/D			AIR CRAFT CABLE	S.S.	Ø3/32; 7-19 strand; AIRCRAFT SPRUCE #05-03900	2
1	1	B/D			L/H THREAD TURNBUCKLE END	S.S.	10-32 UNF; AIRCRAFT SPRUCE #MS21259-3 LH	2
1	1	B/D			R/H THREAD TURNBUCKLE END	S.S.	10-32 UNF; AIRCRAFT SPRUCE #MS21259-3 RH	2
1	1	B/D			BALL & SINGLE SHANK TERMINAL	-	Ø3/32 cable; AIRCRAFT SPRUCE #MS20664C-3	2
			-123	2	TAG	6061	.04 x 1 x 2	1

ASSY QTY
120B/120A

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	UPDATED TITLEBLOCK & REVISION BLOCK, CH'D DWG NO. FROM 407-240-009-101, CH'D PG.#1 TO ASSY. VIEW, PG. #2 TO WIRE ASSY VIEW, MOVED -109 TO PG. #3, DELETED PG. #4.	6/4/09	RJC	
1	CH'D BOM P/N -121 MATERIAL FROM STEEL & FROM PLATE TO ROUND, PER D.W., ADDED NOTE SHEET 3 of 3.	11/3/09	RJC	
2	REMOVED GROOVE FROM P/N-109, ADDED NOTE P/N-120A & -120B ASSEMBLY PER R.W.	11/25/09	RJC	
3	CHANGED TURNBUCKLE ENDS FROM MS21260-009 R&L HAND THREAD. ALL BUY OUTS CHANGED FROM AMERICAN RIGGERS SUPPLY No. PER DAVE.	12/21/09	WP	RW
3A	CORRECTED MODEL USED ON FROM 207 TO 206 A & B	5/13/10	WP	DW



NOTES

1. RBT400221 REPLACES BELL TOOL No. 206-240-003-101

RED BARN MACHINE

TITLE
TOOL - DRIVESHAFT REMOVAL

DWG NO. RBT400221 REV 3A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE
TOLERANCES ON:		APPROVED: D. Weil
DECIMALS		
.XXX ± .005	FRACTIONS ± 1/32	
.XX ± .01	ANGLES ± .5°	
.X ± .1		
UNLESS OTHERWISE SPECIFIED		USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		BELL 206 A & B
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE NTS	DATE 5-20-02	SHEET 1 of 3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1783A

20180718

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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